

Split

Work Order ID 56835 - 1

March 10, 2010 3:51:08 PM



Page 1

Item ID: D3405-041 ~~1234~~

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 10/03/2010 Start Qty: 10.00

Required Date: 17/03/2010 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *AL*

Date: 10-3-10 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3405	Rev B								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3405 Dwg Rev: <u>8</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

10-3-23

10-3-23

5/10/23

114

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Page 2

Item ID: D3405-041

Revision ID:

Item Name: Lug Assembly

Start Date: 10/03/2010 Start Qty: 10.00

Required Date: 17/03/2010 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburr

Form using DT8204 as per Dwg D3405

0.00

0.00

SB 10/03/31

14

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 10/04/01

14

split @ 8

150



Large Fab

Large Fab

Large Fab

Memo

Weld as per Dwg D3405
Identify as D3405-041

0.00

0.00

EL 10-4-19

18

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Page 3

Item ID: D3405-041

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 10/03/2010 Start Qty: 10.00



Required Date: 17/03/2010 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

(8) 100420

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/04/20

(XB)

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

0.00

START TIME: 7:30 AM
OVEN TEMPERATURE: 400 °F
FINISH TIME: 8:00 AM

=> 10/04/21

Yr

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Page 4

Item ID: D3405-041

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 10/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⑧

BR 10-4-21

200

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

ST 474 m-l 10/04/26

⑧

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/27 JF

MF 10-4-26

Picklist Print

March 10, 2010 3:51:11 PM

Page 1

Work Order ID: 56835

Parent Item: D3405-041

Parent Item Name: Lug Assembly

Comments: IPP A 05.09.01 New issue KJ/JLM
IPP B 09.01.28 rev.B drawing EC verified by:DD

Start Date: 10/03/2010

Required Date: 17/03/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3404-1		Manufactured	No			100	Each	9.0000	10.0000			



GHW Lug



EL 10-4-19

57524 X8

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	9	
45372	8	
52515	1	

M304S11GA

Purchased

No



304/316 0.125 Sheet

150 sf

59.1036

1.6211



2.5

18 10-3-23

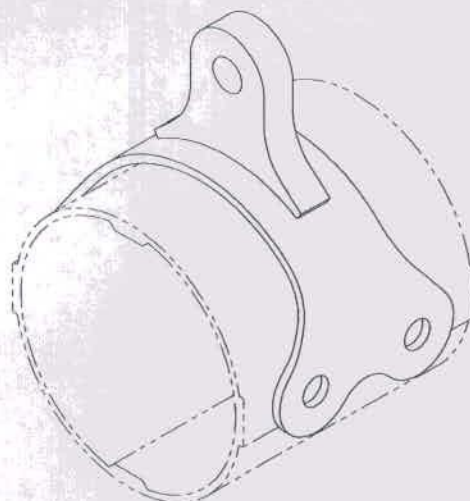
Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	59.1036	
112663	59.1036	

112663

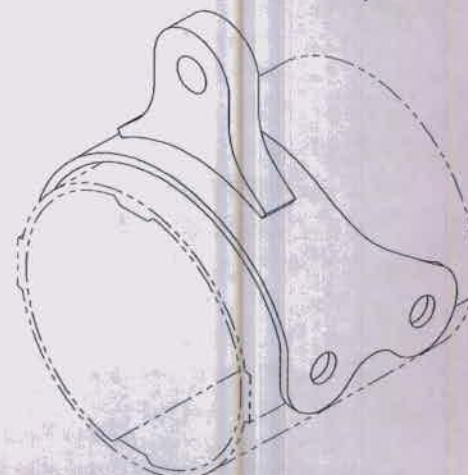
(18)

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



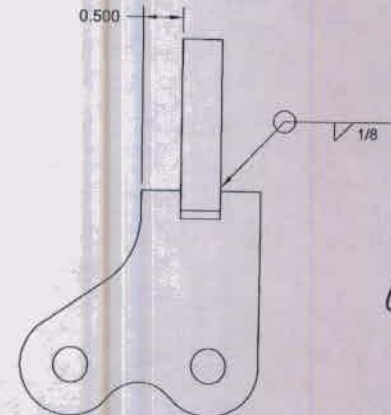
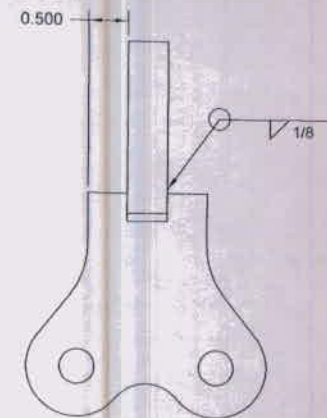
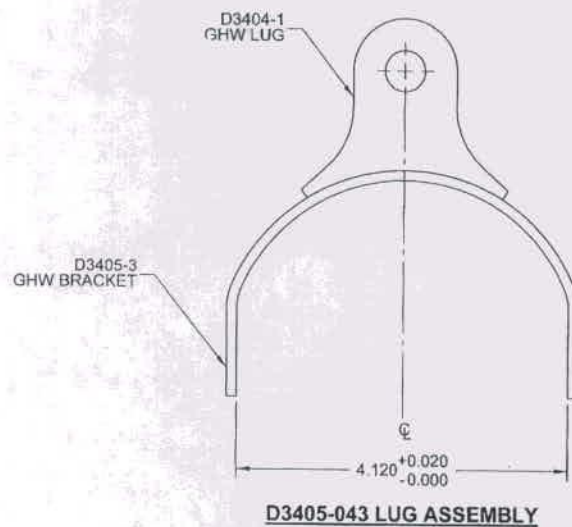
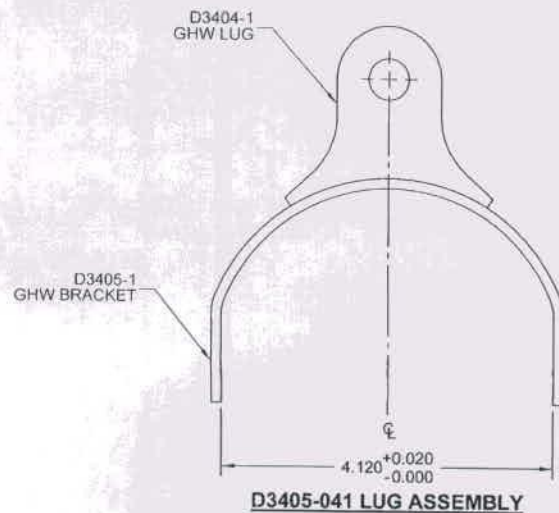
D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/12/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

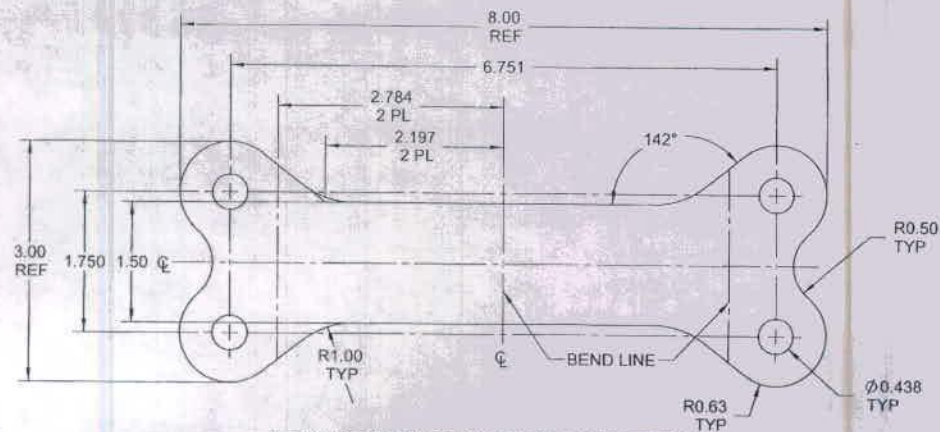
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
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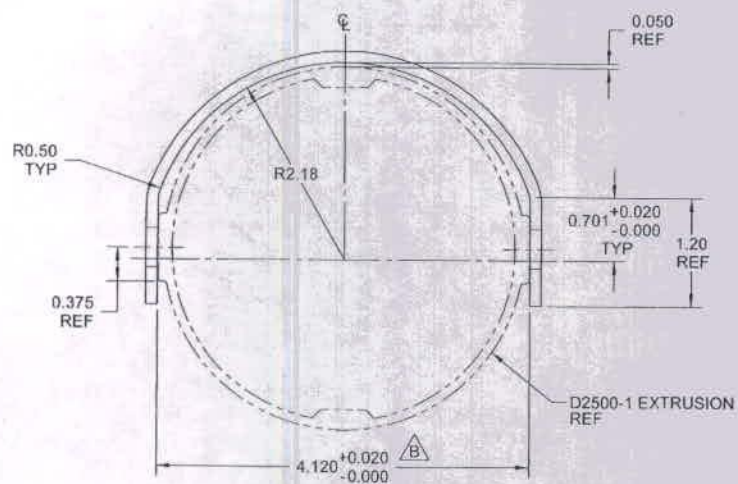
W1056835

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6/12/18 M

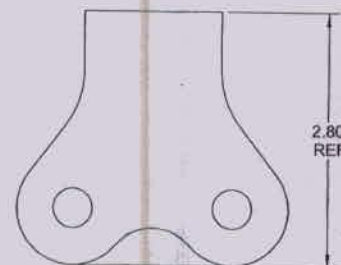
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B SHEET 2 OF 4
MFG. APPR.		TITLE GHW LUG ASSEMBLY	SCALE NTS
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DATE	08.09.19		



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



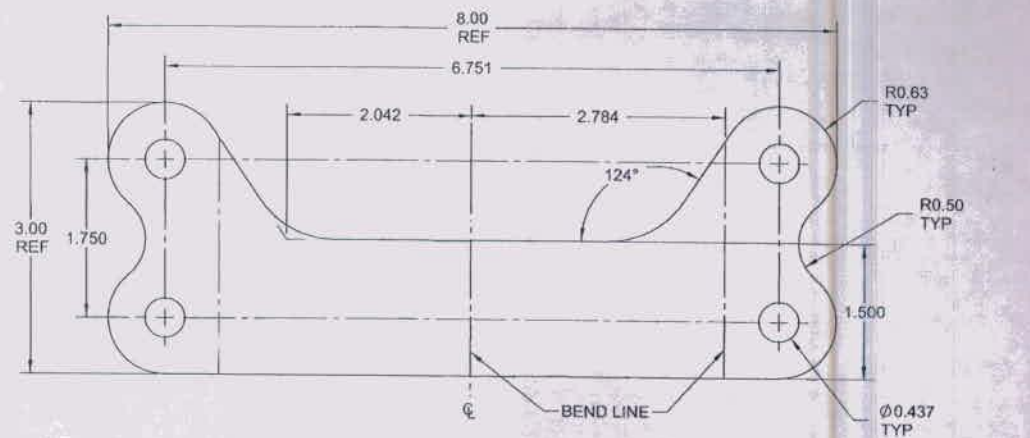
SIDE VIEW FOR REF ONLY

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

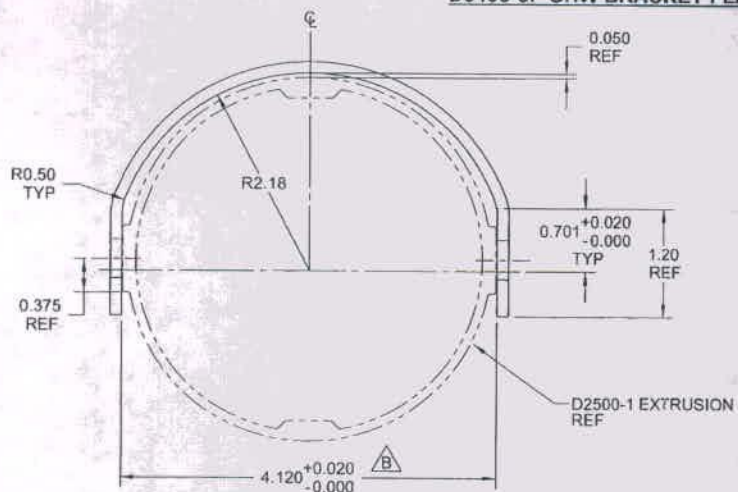
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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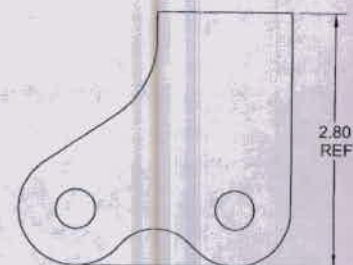
RELEASED



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
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DE APPR.		GHW LUG ASSEMBLY	NTS
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